



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-35
Job Sheet 169013



Part No: D4956-35

Job Qty: 10 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/29/17

Job Tracking No:

Due Date: 12/11/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A SHEETS 6,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/9/17	0.00	0.00	Start Up Waterjet		SL
100	Waterjet	10 pcs		12/9/17	0.00	1.33	Waterjet1		SL
120	QC	10 pcs		12/9/17	0.00	0.00	QC8		SL
130	Brake NC	10 pcs		12/9/17	0.18	0.21	Brake NC 1		SL
140	QC	10 pcs		12/9/17	0.00	0.00	QC5		DAS 38
150	HandFinish	10 pcs		12/11/17	0.00	0.50	HandFinish4		AS DEC 13 2017
160	QC	10 pcs		12/11/17	0.00	0.00	QC3		N
170	Packaging	10 pcs		12/11/17	0.00	0.00	Packaging3	FP-002	HL 12-19
180	QC21-SA	10 Ea		12/11/17	0.00	0.00	QC21		H

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	7	166	0	0

Rockguard 138637

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740		
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490		
8	Wearshoe	16.250Inches ± 0.010	16.260 16.240		
9	Wearshoe	19.750Inches ± 0.010	19.760 19.740		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	INTV Effective : _____		MRB (QSI042) Approval _____																	
Description Work Order Deviation Job No: 169013 Mfg Date: 11/30/17 Start up Operation D4956 - 35 Change No: Operation: Revision: PART NO: Wearplate Art S015949 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																					

10	Wearshoe	21.750inches $\pm$ 0.010	21.760	21.740
11	Wearshoe	25.250inches $\pm$ 0.030	25.280	25.220
12	Wearshoe	25.630inches $\pm$ 0.030	25.660	25.600
13	Wearshoe	6.000inches $\pm$ 0.030	6.030	5.970
14	Wearshoe	12.750inches $\pm$ 0.030	12.780	12.720
15	Wearshoe	0.040inches $\pm$ 0.010	0.050	0.030

Plex 11/29/17 8:52 AM dart.poulin.mano

DOA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.10.23	New Issue	K-J 	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : <u>17/12/13</u>		Step #:		QTY Effective :		MRB (QSI042) Approval DAS 12 9-89 <u>17/12/13</u> Completed By DAS 12 9-89 <u>17/12/13</u> Lead hand / Supervisor Approval Verification <u>PD 17-12-19</u> QC / QA Coordinator Approval <u>PD 17-12-19</u>																																																									
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Applying Axalta cohesion promoter is time consuming. Testing by ENGR indicated that Axalta provides no measurable benefit. Both treated & untreated weepholes held equally well after several days of submersion submersion.				Acceptable to <u>not</u> use Axalta cohesion promoter on weepholes. DEC 13 2017																																																											
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
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